

Work Order ID 132899

Thursday, May 14, 2015 11:31:30 AM

132899

Page 1

Item ID: D4953-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cushion

Start Date: 5/14/2015 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/22/2015 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: mf Date: 5-5-14 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4953	B								

100

0.00

100

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per folio FB293

1-Deburr as required.

30 0 15/05/21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

30 0 15/05/21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval				
Description Work Order Deviation			Disposition					
						Completed By		
						Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Required Date: 5/22/2015 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				30	Ø		DAS 40 9-89 15/05/22
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: ST 545	0.00				30	15		MAY 25 2015
130									
Packaging	Memo	0.00							DAS 26 9-89
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00				MLJ			MAY 26 2015
140									
QC	Memo	0.00							
Quality Control									

MLJ MAY 26 2015

DQA: _____ Date: _____



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Picklist Print

Thursday, May 14, 2015 11:31:30 AM

Page 1

Work Order ID: 132899

132899

Parent Item: D4953-1

D4953-1

Parent Item Name: Cushion

Start Date: 5/14/2015

Required Date: 5/22/2015

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 13.09.30 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4287-1

Manufactured No

f

64.3830

12

D4287-1

Uhmw U-Channel

Location

Loc Qty

Loc Code

ST479a

64.383

131542

64.383

12, 208

W.P.
15/05/21

DQA: _____ Date: _____



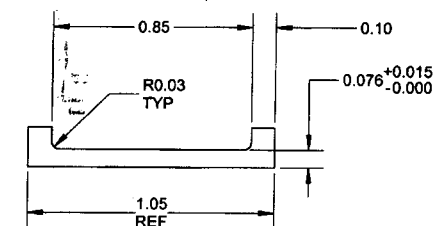
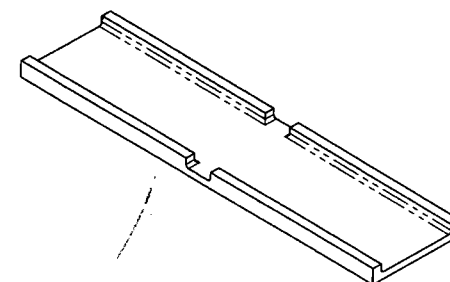
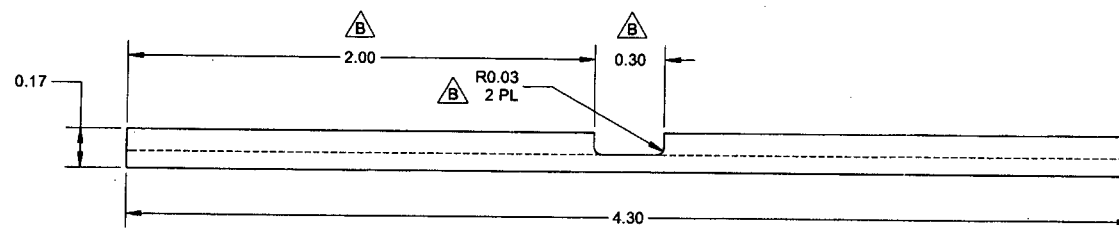
WORK ORDER NON-CONFORMANCE / UPDATE

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mf
132899



1 D4953-1 CUSHION

RELEASED

2015 APR 08
A.P. ECU 15-548

- NOTES:
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 0.03 lbs

APPROVED

B	ADD 0.30 NOTCH, 2 PL PER PAR 14-368, ZN C7-1, C6-1	VS	15.03.24
A	NEW ISSUE	VS	13.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4953	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CUSHION	NTS
DATE	15.03.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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